

Work Order ID 58460



Page 1

May 7, 2010 10:10:43 AM

Item ID: D3570-2

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 07/05/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *10*Date: *10-5-07*

Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3570	Rev E								
100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3570 Dwg Rev: <i>E</i> Prog Rev: <i>E</i> ***GRAIN DIRECTION AS PER DWG*** 2-Deburr if necessary								<i>10-5-11</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

(18)

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

8/10/05/11

+12

QC

Memo

0.00

Quality Control

P10 →

130



Small Fab

0.00

17X

Small Fab

Memo

0.00

Small Fab

- 1-Form as per Dwg D3570 Using DT8945
- 2-Cut excess materialas per Dwg D3570.
- 3-Drill as per Dwg D3570 Using Dt8946

⇒ M-k 10/05/31

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/05/01

+17

WO: 58460

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/05/11	# 00	Tool AM +1 For QC inspection template	S	10/05/11	+1		S 10/05/11

Part No: D3570-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Quality System Instruction 012

INSPECTION

Procedure Issue Date: 08.04.01 Issue No.: 13

ISSUE REVISION: J

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No Change			
2	J	Revised issue revision page	09.09.24		
3	A	No Change			
4	I	Revised Section 4.1	09.09.24		
5	J	Revised Section 4.1	09.09.24		
6	B	No Change			
7	A	No Change			

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Chemical Conversion Coat per QSI005 4.1

0.00

17

BK 10-6-2

HandFinish

Hand Finishing

160



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

=> M 10/06/08

17

Q

Powdercoat

Powder Coating

Memo

START TIME: 7:15AM
OVEN TEMPERATURE: 320°
FINISH TIME: 7:45AM

0.00

170



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

17 BK 10-6-3



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Setup

Start



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Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location J45ASet Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-6-4 SF (17)

10/06/07 JJ

MF

10-6-7

DART AEROSPACE LTD	Work Order:	38460
Description: Bracket	Part Number:	D3570-2
Inspection Dwg: D3570	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	C	Prototype Approval:	N/A
Date:	10-5-11	Date:	10-5-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	[Signature]

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

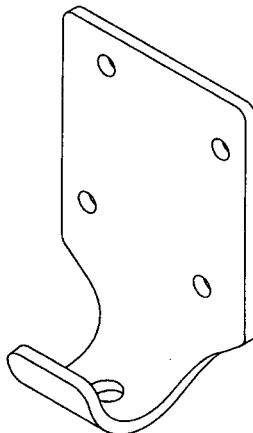
SUBJECT TO AMENDMENT

WITHOUT NOTICE

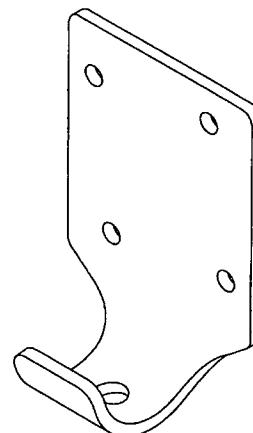
WORK ORDER

NO. 58460

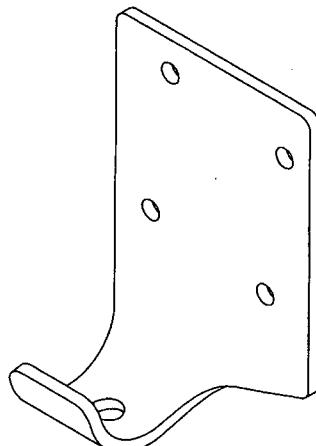
PRO-5-07



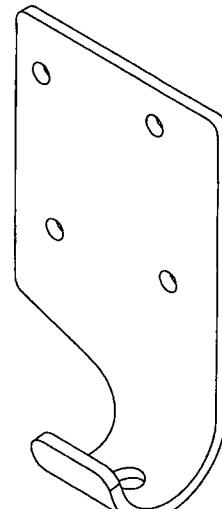
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

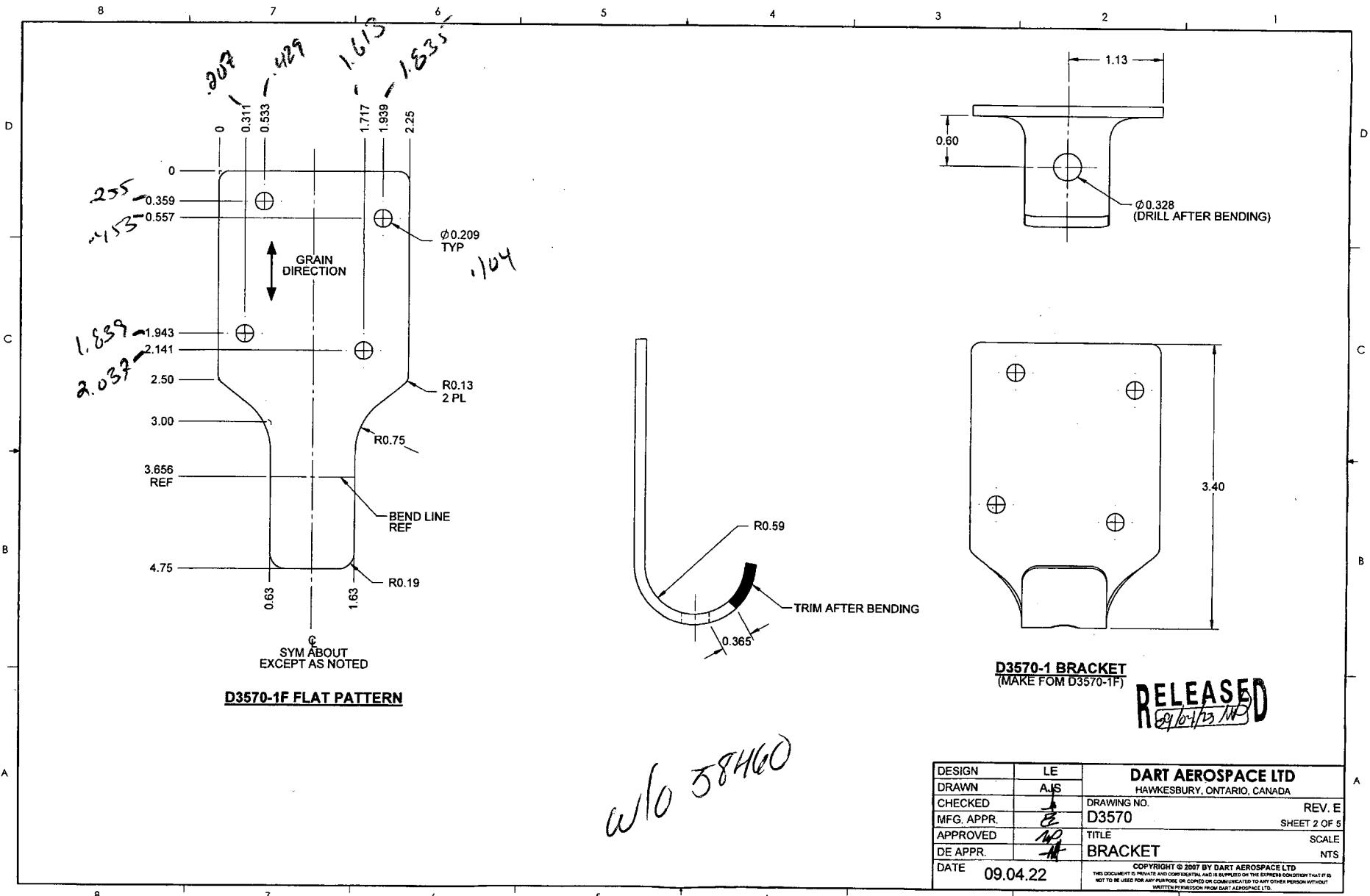
RELEASED
09/04/07

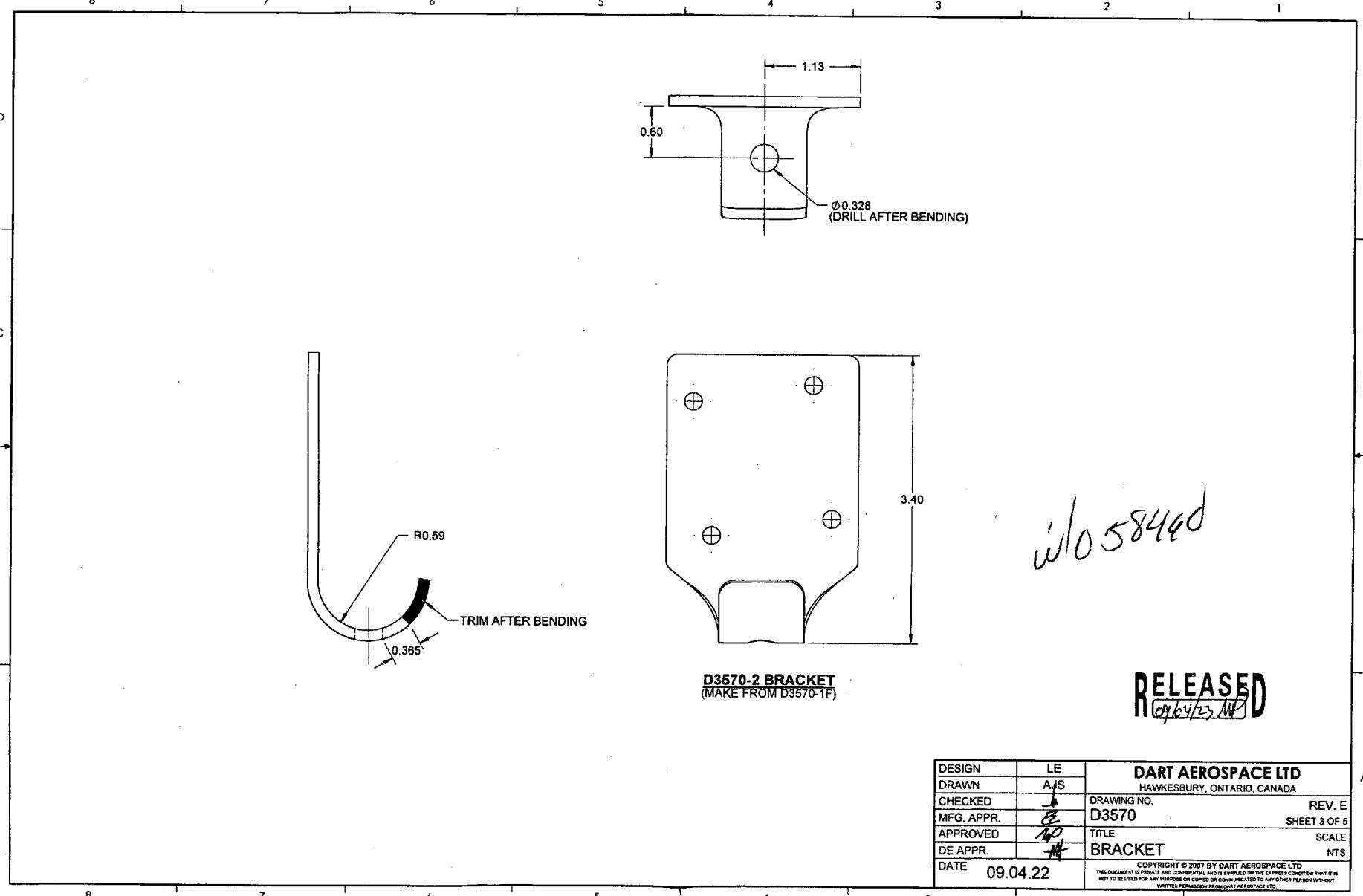
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

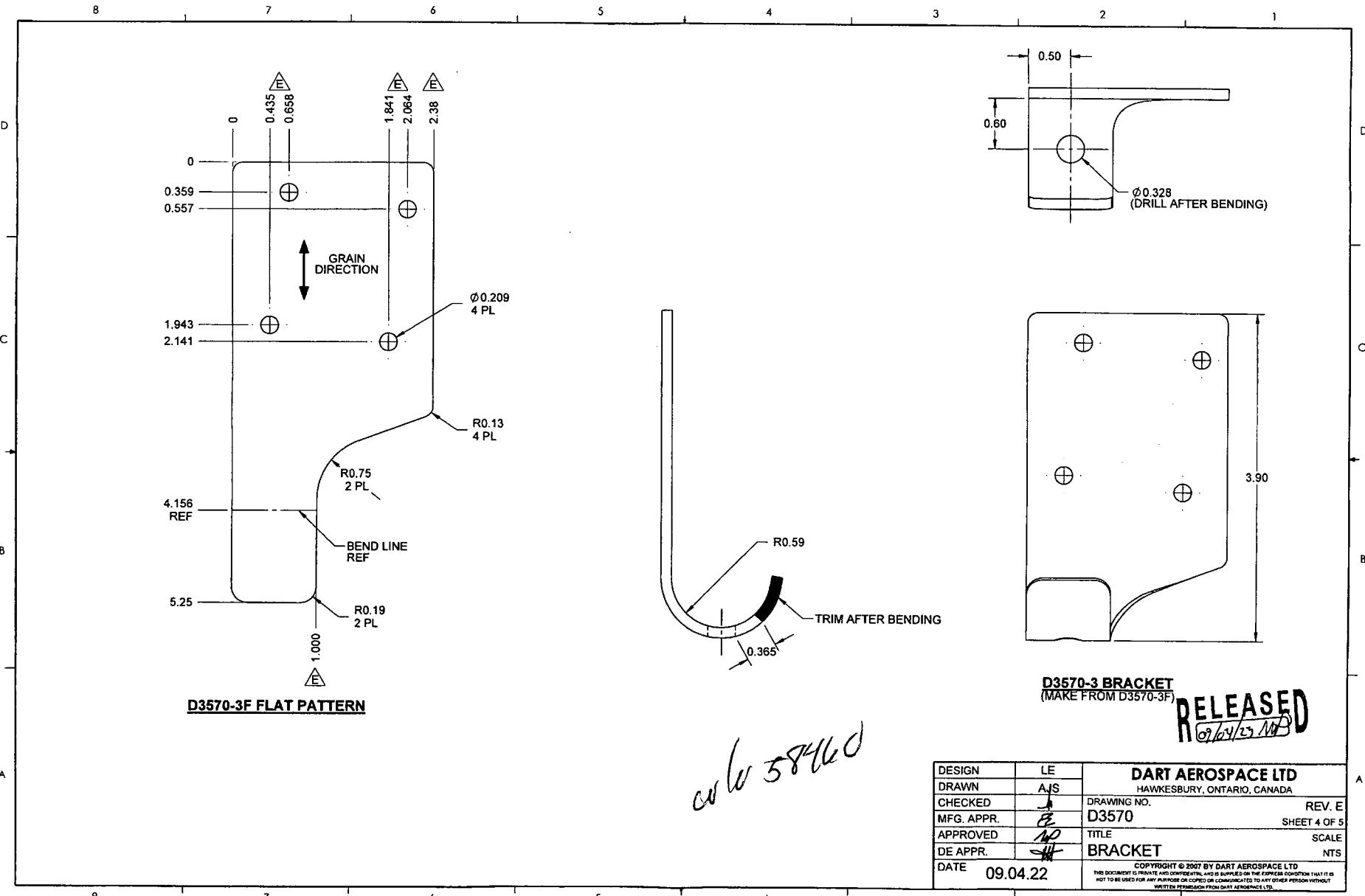
E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.			AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.			AJS	09.04.01
C	UPDATE DIMS FOR CLARITY			LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50			LE	07.04.16
A	NEW ISSUE			LE	07.02.07
REV.	DESCRIPTION		BY	DATE	
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS	DRAWING NO. D3570			
CHECKED		REV. E SHEET 1 OF 5			
MFG. APPR.	Z	TITLE BRACKET			
APPROVED		SCALE NTS			
DE APPR.		DATE 09.04.22			

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